

Work Order ID 92213

Tuesday, October 23, 2012 11:08:04 AM

92213

BFR

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Item ID: D3440-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Contoured Detent Clip Base (Supersedes B67-43001-217)
 Start Date: 10/23/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/9/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 12-10-23 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3440	Rev A								

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut blank: 1.250" x 1.250" x 2.000" long
 12/10/26

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Machine as per Folio FA586 and Dwg D3440Dwg Rev: Identify as
 D3440-5Folio Rev: Debur
 12-10-26

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control
 12/10/27

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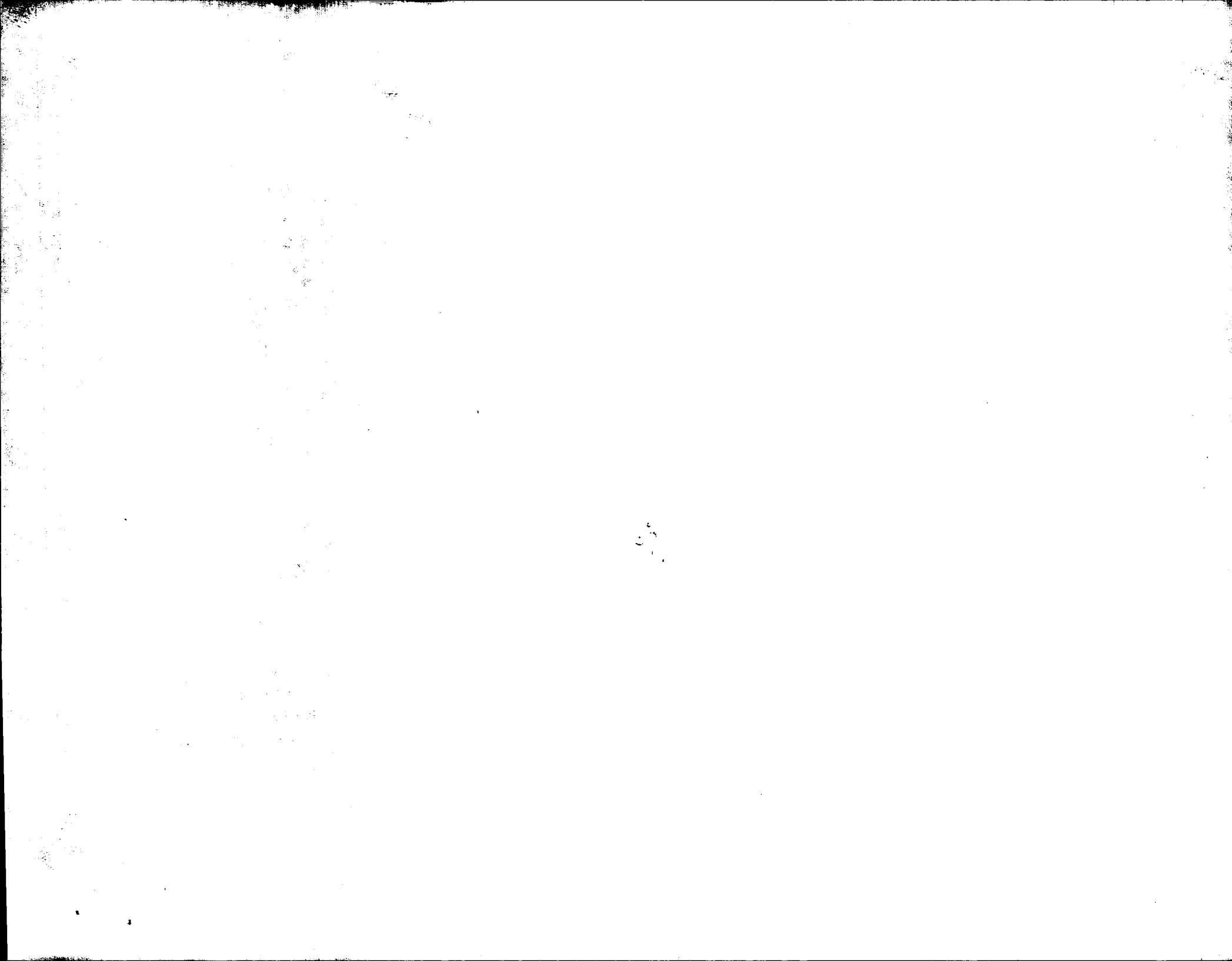
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		DAS 25 9-83 12-10-28		⑥			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: SWA Memo	0.00 0.00				6x		Sp 12-10-29.	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/10/31 MCJ 12-10-29	



Picklist Print

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Work Order ID: 92213

Parent Item: D3440-5

Parent Item Name: Contoured Detent Clip Base (Supersedes B67-43001-217)

Start Date: 10/23/2012

Required Date: 11/9/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A05.06.30New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X01.250 6061 T6 Bar .250 X 1.25		Purchased	No			100	f	73.3000	0.1771	0.7456842			

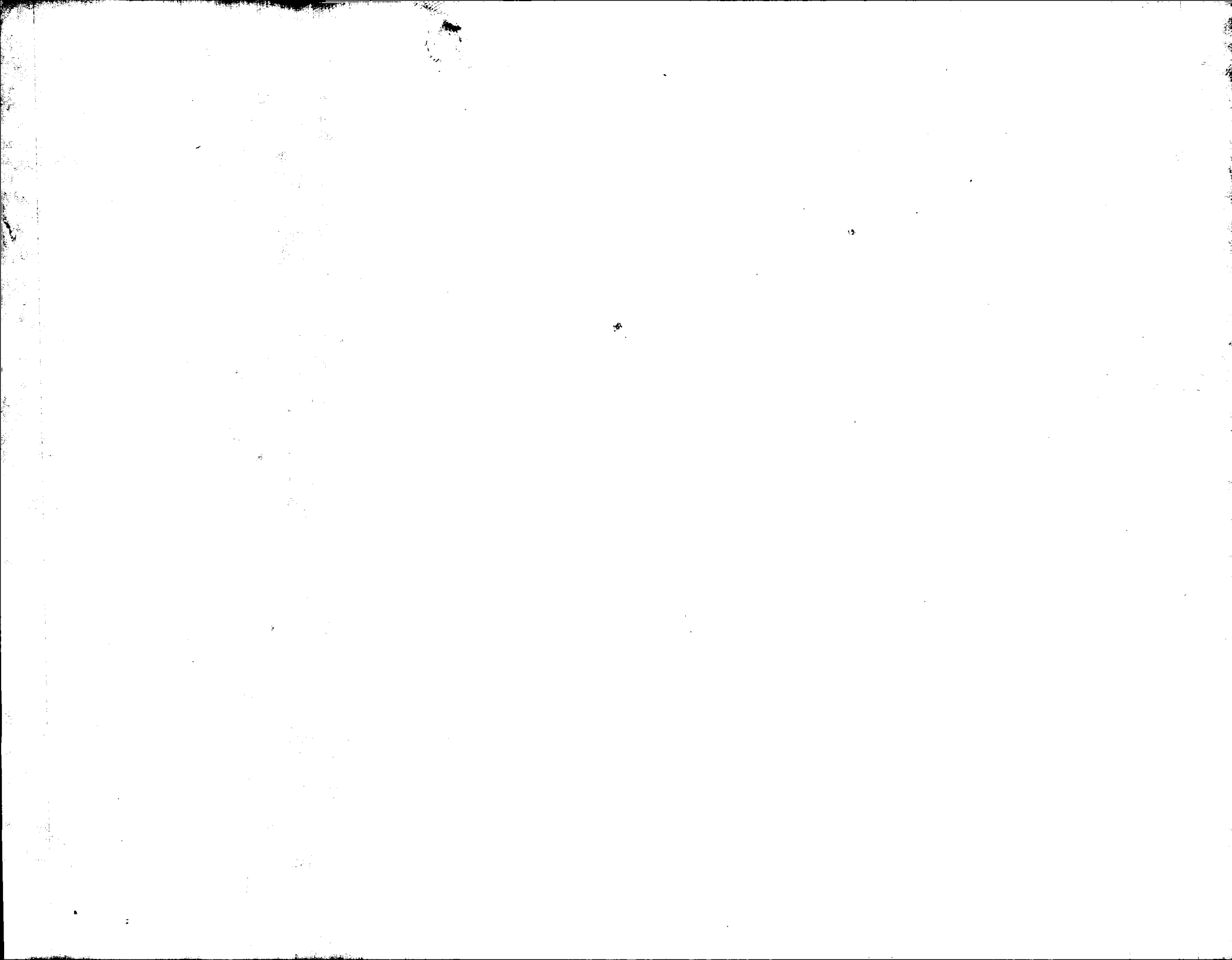
D.A 12/10/26

M6061T6 B 1.250 X 1.250

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT001	73.3	
109058	20	
109140	31.8	
10956	21.5	

119318

1.025 ft

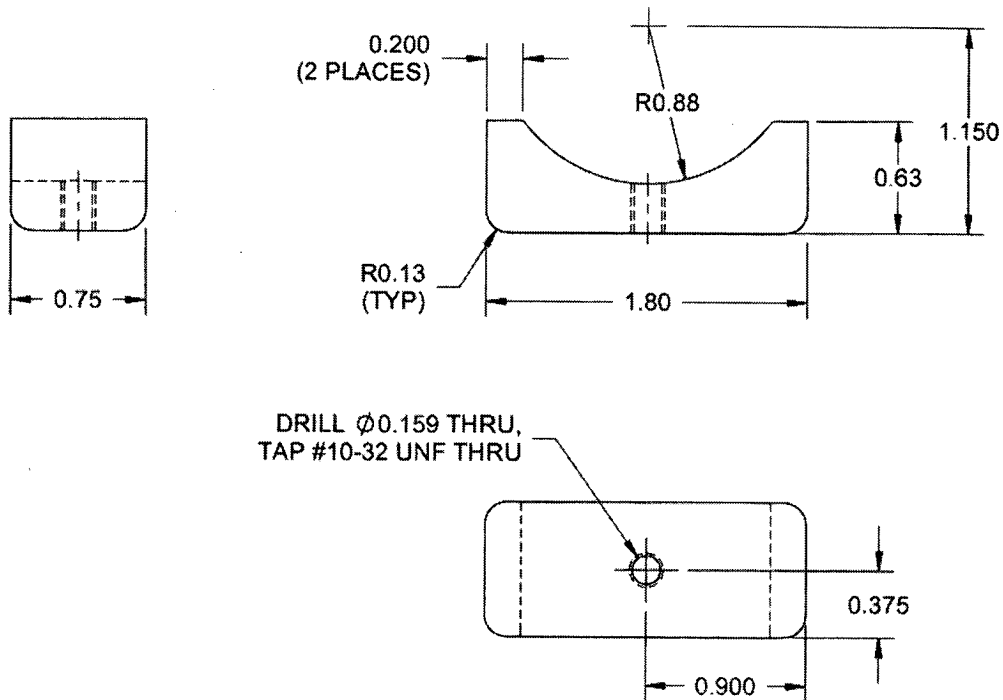


DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3440	REV. A SHEET 3 OF 7
DATE 05.06.02	TITLE BLADE FOLD KIT PARTS		SCALE 1:1

RELEASED
[Signature]
05/08/18

#92013



D3440-5 CONTOURED DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-217

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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